

Date: Wednesday, 11/23/2005 4:03:30 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT X-TUBE EXT HEIGHT(-013)
Job Number	: 24947		
Estimate Number	: 10563		
P.O. Number	:	Part Number	: D205596107
This Issue	: 11/23/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D205596107
First Issue	: / /	Project Number	: N/A
Previous Run	: 23104	Drawing Revision	: A
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 1/15/2006
Comment	: Est Rev:D 05.03.21 Added bending procedure KJ/JLM		

Qty: 1 **Um:** Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

2.0	D2890	Aft Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:
Qty Part number Description Batch
1 D2890 Aft Crosstube *B22534*

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE
Bend D2890 as per Dwg D2890 and Folio FT002

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Deburr and Polish

5b re-alodine

IT 06-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Part Number: D205596107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

9.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
Inspect dimensions. Conformity check and sign off by engineering.

10.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
1-Cut as per Dwg D205-596-107

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

13.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/23/2005 4:03:30 PM
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Job Number: 24947

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

15.0

D2856600

Abrasion Strip



Comment: Qty.: 1.6810 f(s)/Unit Total : 1.6810 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(10.09") Abrasion Strip

16.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support

17.0

MS2192028

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28 Clamp

18.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

A/R Sikaflex -291

Expiry date:

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location: _____

PPP Rev: _____

21.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/09/2006 10:56:34 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 24947	Customer	: Dart Helicopters Services
Estimate Number	: 10563	DWG Name	: AFT X-TUBE EXT HEIGHT(-013)
Purchase Order #	:	Part Number	: D205596107
Complete Date	: / / : : AM	DWG Number	: D205596107
		Rev.	: A

DUE DATE	ORDERED	DELIVERED
15/01/2006	1	0

5.0 LANDING GEAR 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
19/04/2006	TITL01: Titley, Ian	Run	0.000	0.63	\$8.19	0.63	18.76
19/04/2006	TITL01: Titley, Ian	Run	0.000	0.50	\$6.50	0.50	14.89
20/04/2006	PAQU03: Paquette, Dan	Run	0.000	2.00	\$37.82	2.00	86.61
20/04/2006	PAQU03: Paquette, Dan	Run	0.000	0.25	\$4.73	0.25	10.83
20/04/2006	TITL01: Titley, Ian	Run	0.000	2.00	\$26.00	2.00	59.54

Subtotal:	QTD:	0	CTD:	0	5.38	\$273.87
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6.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
19/04/2006	MYRE01: Myre, Alexandre	Run	0.000	0.75	\$9.98	0.75	22.86
19/04/2006	MYRE01: Myre, Alexandre	Run	0.000	0.75	\$9.98	0.75	22.86

Subtotal:	QTD:	0	CTD:	0	1.50	\$65.68
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		TIME	COST
	Machine Time:	6.88	\$236.35
	Labor:	6.88	\$103.20
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$0.00
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$339.55

COST PER UNIT:	\$339.55
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*Closed
No tube / No up*